

SPLIT-2

~~Black~~

White

Dart Aerospace Ltd

Date: Thursday, 6/21/2007 2:28:39 PM
User: Kim Johnston

Process Sheet

Customer:	: CU-DAR001 Dart Helicopters Services	Drawing Name:	: SADDLE FITTING, AFT (OUTBOARD/INBOARD)
Job Number:	: 33042	Part Number:	: D2573
Estimate Number:	: 10533	Drawing Number:	: D2573 REV E
P.O. Number:	: N/A	Project Number:	: N/A
This Issue:	: 6/21/2007 S.O. No. : N/A	Drawing Revision:	: E
Prsht Rev.:	: NC	Material:	: N/A
First Issue:	: N/A Type : MACHINED PARTS	Due Date:	: 7/11/2007
Previous Run:	: 32167	Qty:	: 2
Written By:	: <u>JA 07.02.22</u>		
Checked & Approved By:	: <u>JA 07.02.22</u>		
Comment:	: Est. 1 As Per RevE 06-01-27 JLM		

Additional Product

Job Number



Seq #	Machine Or Operation:	Description:
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10	D6101007	7075-T7351 8.25X7.75X2.5
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Comment: Qty: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)
7075-T7351 8.25X7.75X2.5
Make from D6101-007 billet for D2573
Ensure that grain is along 7.75" length
Batch No: 1225353

20	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
Program Batch No. SA Double check by: J.F.

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
4-Deburr and remove all machining marks
5-Tumble to remove sharp edges.

SA/PM

01.01

30	MILLING CONV	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
Machine keyway as per dwg D2573 & D2574

SA/PM

40	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA/PM

01.07.16

Date: Thursday, 6/21/2007 2:28:39 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 33042

Part Number: D2573

Job Number:



Seq. #:

Machine Or Operation:

Description:

50

QC8

SECOND CHECK



Comment: SECOND CHECK

JF 07/07/16

60

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

HD 07-07-17

(x2)

70

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat GREEN SANDTEX (Ref. 4.3.5.1) as per QSI 005 4.3

White m 101575
M/B 07-07-17

80

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FD 07/07/17 (2)

90

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 433

07/07/17 (2)

100

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.07.18

Job Completion



07-07-18

DART AEROSPACE LTD	Work Order:	22-10
Description: Saddle, Aft Outboard	Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	0.439	0.441	0.439	0.438		
B	1.745	1.755		1.751	1.750	1.752	1.751		
C	3.495	3.505		3.500	3.500	3.506	3.506		
D	1.745	1.755		1.750	1.750	1.751	1.751		
E	7.990	8.010		8.001	8.000	8.003	8.000		
F	0.490	0.510		0.506	0.504	0.505	0.504		
G	0.257	0.262	DT8683	0.257	0.258	0.258	0.258		
H	0.375	0.380	DT8684	0.376	0.377	0.377	0.377		
I	0.490	0.510		0.503	0.503	0.503	0.504		
J	1.174	1.184		1.173	1.178	1.178	1.178		
K	0.558	0.578		0.568	0.571	0.571	0.571		
L	1.174	1.184		1.177	1.178	1.178	1.178		
M	1.365	1.375		1.370	1.368	1.368	1.368		
N	2.495	2.505		2.498	2.500	2.501	2.498		
O	4.119	4.129		4.124	4.121	4.121	4.122		
P	0.115	0.135		0.124	0.123	0.123	0.123		
Q	0.115	0.135		0.134	0.135	0.135	0.135		
R	0.240	0.260		0.230	0.249	0.249	0.248		
S	0.115	0.135		0.123	0.123	0.120	0.124		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.231	3.230	3.230	3.230		
V	0.230	0.250		0.242	0.242	0.241	0.243		
W	0.115	0.135		0.127	0.121	0.123	0.121		
X	0.308	0.313		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.761	0.761	0.761	0.761		
Z	0.352	0.372		0.364	0.358	0.361	0.360		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.635	0.626	0.634	0.625		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.248	0.246	0.245	0.247		
AE	1.500	1.520		1.511	1.511	1.512	1.509		
AF	0.115	0.135		0.125	0.132	0.132	0.130		
AG	0.240	0.280		0.255	0.255	0.260	0.265		
AH	0.240	0.260		0.252	0.250	0.253	0.251		
AI	2.000	2.020		2.002	2.001	2.003	2.000		
AJ	0.023	0.043		0.033	0.033	0.037	0.037		

Accept/Reject

Measured by: S.D./-2.6	Audited by: J.F.
Date: 07/07/13	Date: 07/07/13

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

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DART AEROSPACE LTD		Work Order:	22
Description: Saddle, Aft Outboard		Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		0.500	0.500	0.500	0.500		
G	0.257	0.262	DT8683	0.258	0.258	0.258	0.258		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.500	0.500	0.500	0.500		
J	1.174	1.184		1.178	1.178	1.178	1.178		
K	0.553	0.578		0.564	0.564	0.564	0.564		
L	1.174	1.184		1.178	1.178	1.178	1.178		
M	1.365	1.375		1.369	1.369	1.369	1.369		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.121	4.121	4.121	4.121		
P	0.115	0.135		0.123	0.123	0.123	0.123		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.249	0.249	0.249	0.249		
S	0.115	0.135		0.120	0.121	0.120	0.120		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.240	0.240	0.240	0.240		
W	0.115	0.135		0.123	0.123	0.123	0.123		
X	0.308	0.313		0.307	0.307	0.307	0.307		
Y	0.760	0.765		0.762	0.762	0.762	0.762		
Z	0.352	0.372		0.364	0.365	0.364	0.364		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.625	0.621	0.625	0.620		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.246	0.248	0.242	0.241		
AE	1.500	1.520		1.511	1.511	1.511	1.511		
AF	0.115	0.135		0.135	0.132	0.130	0.131		
AG	0.240	0.280		0.255	0.257	0.265	0.265		
AH	0.240	0.260		0.250	0.250	0.253	0.252		
AI	2.000	2.020		2.001	2.002	2.002	2.002		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		

Accept/Reject

Measured by:	JML	Audited by:	JF
Date:	07/07/11	Date:	07/07/11

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

BART AEROSPACE LTD

Work Order: 33042

Part Name: Saddle Air Outboard

Part Number: D2573

Drawing: Dwg: D2573 Rev: E

Dimensions highlighted in inspection sheet drawing D2573 Rev: E and record below:

Recorded Actual Dimensions

Dim	Unit	Max	Call to 2nd Gauge	1	2	3	4	By
1		4.44		4.39	4.39			
2		1.75		1.700	1.750			
3		3.50		3.500	3.500			
4		1.75		1.750	1.750			
5		8.00		8.002	8.005			
6		4.99		4.995	5.000			
7		2.58		2.58	2.58			
8		3.76		3.76	3.76			
9		5.06		5.06	5.04			
10		1.12		1.12	1.12			
11		5.72		5.72	5.71			
12		1.17		1.17	1.17			
13		1.37		1.370	1.370			
14		2.49		2.498	2.498			
15		4.12		4.124	4.124			
16		0.12		0.123	0.123			
17		0.13		0.135	0.135			
18		0.25		0.250	0.251			
19		0.12		0.123	0.123			
20		0.18		0.188	0.188			
21		3.23		3.232	3.232			
22		0.25		0.25	0.25			
23		0.12		0.124	0.124			
24		0.31		0.310	0.310			
25		0.76		0.763	0.763			
26		0.36		0.366	0.365			
27		0.50		0.500	0.500			
28		0.62		0.627	0.628			
29		0.06		0.063	0.063			
30		0.25		0.251	0.251			
31		1.51		1.510	1.511			
32		0.13		0.135	0.135			
33		0.20		0.200	0.200			
34		0.25		0.251	0.251			
35		2.00		2.002	2.002			
36		0.03		0.033	0.033			

Accept/Reject

S.A.
27-07-16Audited by
Date

J.F. 27/07/16

Date	Change	Revised by
17-09-26	New Issue	RF
10-11	Re-format. Added Rev. D	KJ
05-05	Re-format. Added DT8682, DT8683, DT8684	KJ
05-05	Added dimension A1	KJ/RF
12-05	Added dimension A1	KJ/JLM

DART AEROSPACE LTD		Work Order:	33042-
Description: Saddle, Aft Outboard		Part Number:	D2573
Ins section Dwg: D2573 Rev. E		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	.438	.438	.438	.438		
B	1.745	1.755		1.740	1.740	1.740	1.740		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.740	1.740	1.740	1.740		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.496	.498	.498	.497		
G	0.257	0.262	DT8683	.258	.258	.258	.258		
H	0.375	0.380	DT8684	.376	.376	.376	.376		
I	0.490	0.510		.501	.501	.501	.501		
J	1.174	1.184		1.171	1.171	1.171	1.171		
K	0.558	0.578		.570	.571	.567	.560		
L	1.174	1.184		1.171	1.171	1.171	1.171		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.501	2.498	2.498	2.498		
O	4.119	4.129		4.123	4.124	4.124	4.124		
P	0.115	0.135		.123	.124	.123	.122		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.247	.250	.247	.250		
S	0.115	0.135		.122	.122	.122	.122		
T	0.178	0.198		.178	.178	.178	.178		
U	3.210	3.250		3.232	3.232	3.232	3.232		
V	0.230	0.250		.244	.242	.243	.242		
W	0.115	0.135		.124	.122	.124	.124		
X	0.308	0.313		.311	.310	.310	.310		
Y	0.760	0.765		.762	.763	.763	.763		
Z	0.352	0.372		.363	.364	.362	.363		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.624	.632	.627	.626		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.246	.247	.249	.247		
AE	1.500	1.520		.511	1.511	1.511	.510		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.253	.260	.260	.260		
AH	0.240	0.260		.250	.252	.252	.252		
AI	2.000	2.020		2.002	2.002	2.003	2.001		
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject

Measured by:	JD
Date:	01.01.15

Audited by:	JF
Date:	07.07.10

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

